

December-14-11 10:35:40 AM

Page 1

Setup Start *NS1*

Stop *NS2*

Customer:

Run Start *NR1*

Stop *NR2*

Date:

**Insp.
Stamp**

Rev B

0.00

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

0.00,,

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod

3-Grind End Plate flush

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77644***77644***

Page 3

December-14-11 10:35:41 AM

Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 14/12/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

180

0.00

180

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod 114514

6-Grind End Plate flush

7-Install last rivet as per Dwg.

12.01.06

10

12.01.06
12/01/06

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77644

December-14-11 10:35:41 AM

77644

Page 4

Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop ***NS2***

Start Date: 14/12/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	8/12/10/1						
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8/12/10/1						10 LH
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	12/01/09						10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 77644

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77644

Page 5

Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 14/12/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

220

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

OF

10X11 M-12/04/12
LH

230

Wing Walk as per dwg QSI005 4.4 Batch 119094

0.00

230

HandFinish

Hand Finishing

Memo

0.00

10 BL 15-1-13.

240

QC3- Inspect Part Finish

0.00

240

QC

Quality Control

Memo

0.00

10 htl / 6 12/01/13
COUNTED & MEASURED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77644

December-14-11 10:35:41 AM

77644

Page 6

Item ID: D350-591-311

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop

NS2

Start Date: 14/12/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311								
	Location: _____								

Rev [Signature]

SP12-01-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77644***77644***

Page 7

December-14-11 10:35:41 AM

Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 14/12/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

M.L.J 12/01/20
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-14-11 10:35:44 AM

Page 1

Work Order ID: 77644

77644

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 14/12/2011

Required Date: 15/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3272-1 JLM
 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
 by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	0.0000	1	10			
\ *D3272-1*					B77797				**				
Step					B77359								
D3067-1		Manufactured	No			110	Each	87.0000	1	10			
\ *D3067-1*									**				
End Plate													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA016	87							
					67582	2							
					68214	1							
					76179	84							
D3219-1		Manufactured	No			110	Each	66.0000	2	20			
D3219-1									**				
Plate													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA016	66							
					73410	12							
					76226	54							
D3066-1		Manufactured	No			180	Each	106.0000	2	20			
\ *D3066-1*									**				
Spacer													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA015	106							
					75076	6							
					76180	100							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

December-14-11 10:35:44 AM

Work Order ID: 77644

77644

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 14/12/2011

Required Date: 15/02/2012

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4

Purchased

No

180

Each

3,026.000

16

160

MS20600-AD4W4

Rivets

**

Ac 12/01/06

Location

Loc Qty

Loc Code

ST321

3021

116188

59

117364

253

117601

200

117885

195

118840

1089

119860

225

119883

1000

(x1160)

WA018

5

116712

5

D3065-041

Manufactured

No

180

Each

12.0000

1

10

D3065-041

Step Leg Assembly Hi

**

B77054 Ac 12/01/06

Location

Loc Qty

Loc Code

WA013

12

76193

12

D3067-1

Manufactured

No

180

Each

87.0000

1

10

D3067-1

End Plate

**

Ac 12-01-06

Location

Loc Qty

Loc Code

WA016

87

67582

2

68214

1

76179

84

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

December-14-11 10:35:44 AM

Page 3

Work Order ID: 77644

77644

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 14/12/2011

Required Date: 15/02/2012

Start Qty: 10.00

Required Qty: 10.00

AN3-35A

Purchased

No

250

Each

103.0000

2

20

AN3-35A

**

Bolt

Location

Loc Qty

Loc Code

ST353

103

119449

100

119641

3

Manufactured

No

250

Each

107.0000

2

20

D3235-1

D3235-1

**

Mounting Lug

Location

Loc Qty

Loc Code

ST481

107

73411

7

75547

100

Manufactured

No

250

Each

42.0000

1

10

D3278-041

D3278-041

**

Support Assembly

Location

Loc Qty

Loc Code

ST481

42

76169

35

76170

7

Purchased

No

250

Each

0.0000

16

160

AN960JD416

NAS1149D0463J

AN960.ID416

**

Washer

AN960JD516

NAS1149D0563J

Purchased

No

250

Each

0.0000

4

40

AN960.ID516

**

Washer

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-14-11 10:35:45 AM

Work Order ID: 77644

77644

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 14/12/2011

Required Date: 15/02/2012

Start Qty: 10.00

Required Qty: 10.00

AN5-36A

Purchased

No

250

Each

105.0000

2

20

AN5-36A

Bolt

**

Location

Loc Qty

Loc Code

ST340

105

119449

30

119641

75

D2618

Manufactured

No

250

Each

112.0000

2

20

D2618

Bushing

**

Location

Loc Qty

Loc Code

ST019

112

74458

12

76130

100

D2230-3

Manufactured

No

250

Each

217.0000

4

40

D2230-3

Lug

**

Location

Loc Qty

Loc Code

ST480

217

53881

4

70973

1

75546

14

76642

198

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

December-14-11 10:35:45 AM

Work Order ID: 77644

77644

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 14/12/2011

Required Date: 15/02/2012

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

205.2445 1.2 12

D2856-400

Abraison Strip

**

Location

Loc Qty

Loc Code

ST409

205.2445

63735

0.6696

68076

0.3149

71164

21.66

73491

182.6

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased No

250 Each

7,032.000 2

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

7032

117441

16

117885

32

118451

5

118927

3

119017

5994

119075

982

AN4-13A

Purchased No

250 Each

746.0000 8

AN4-13A

Bolt

**

Location

Loc Qty

Loc Code

ST357

746

118078

17

118838

129

119449

500

119798

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

December-14-11 10:35:45 AM

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Work Order ID: 77644

77644

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 14/12/2011

Required Date: 15/02/2012

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

2,142.000

2

20

MS21042L 5

**

Location

Loc Qty

Loc Code

ST300

2142

116105

5

116548

43

117611

52

118179

496

118910

46

119109

1500

MS21042L4

Purchased

No

250

Each

9,264.000

8

80

MS21042L 4

**

Location

Loc Qty

Loc Code

ST300

9264

117441

51

117601

342

118451

133

119017

3738

119075

5000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

40

AN960JD10

**

Washer

119537 12/1/95/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>QD</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005.4.3
BLACK ANTI-SKID PAINT PER DART QSI 005.4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTS

WITHOUT NOTICE
WORK ORDER

NO 77644 *M.C.J*
11/12/14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

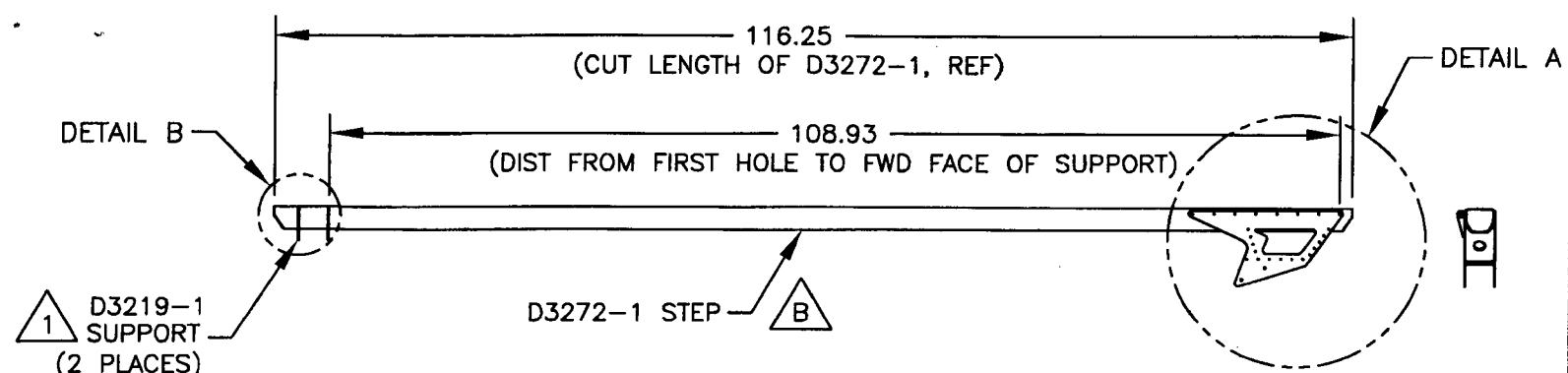
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

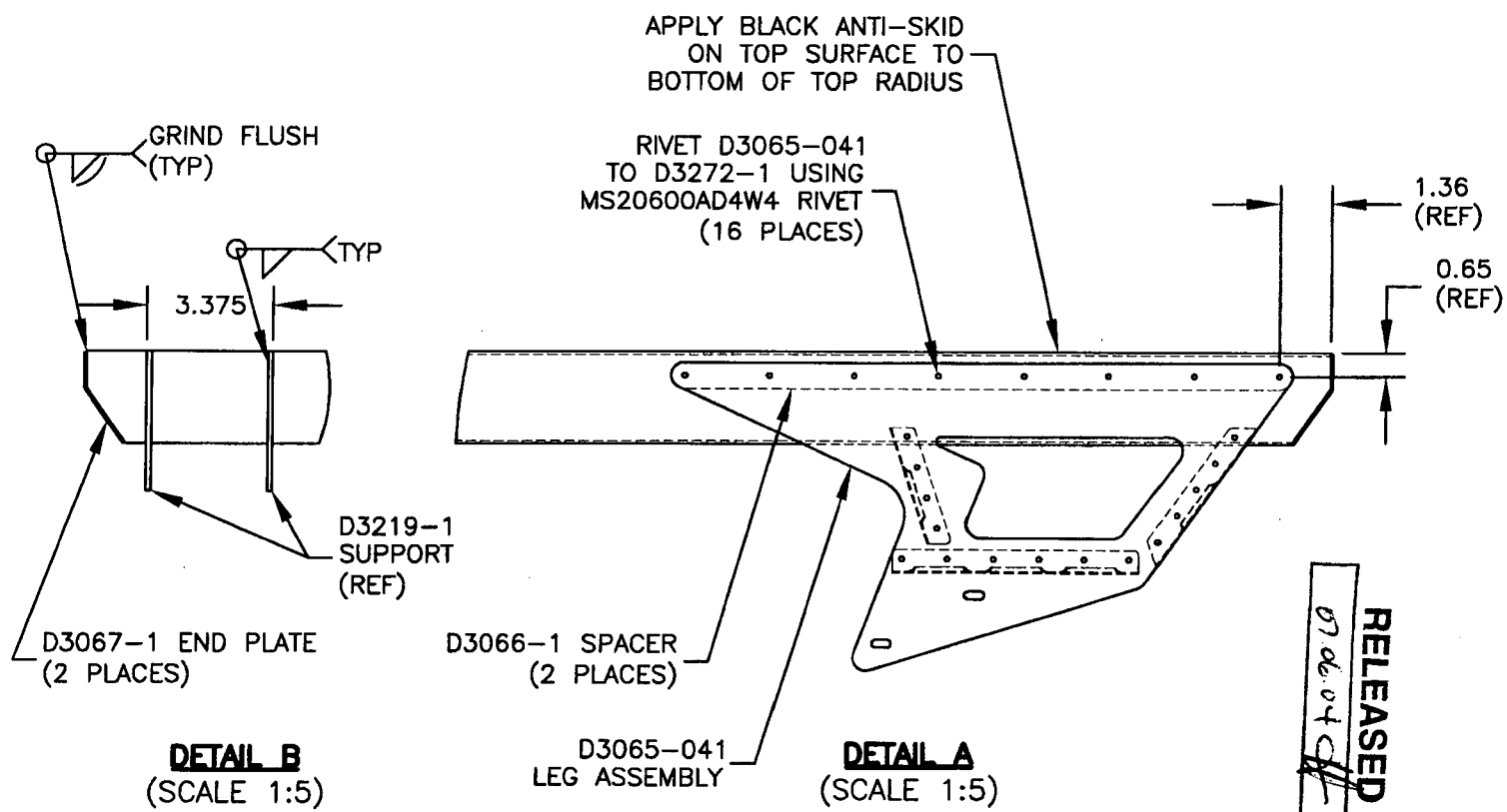


DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	TITLE	DRAWING NO.	SHEET 2 OF 3
07.05.18	STEP ASSEMBLY, HI LONG	D3272	SCALE 1:20

77644



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

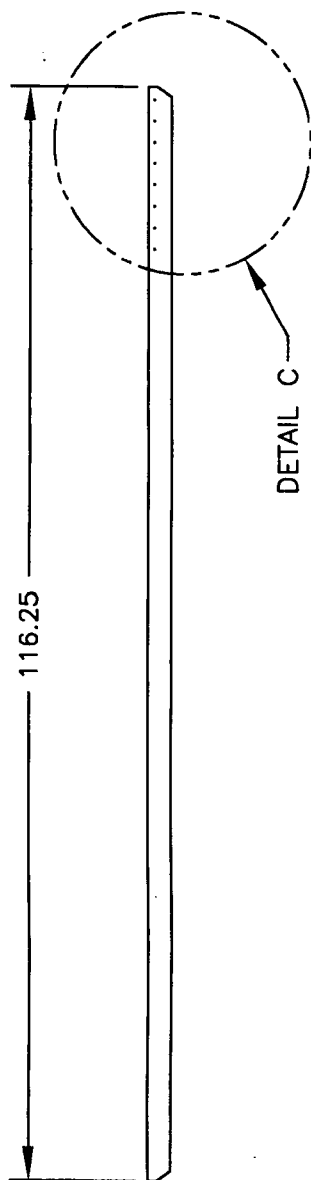
NOTE: Date & initial all entries



DESIGN 40	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

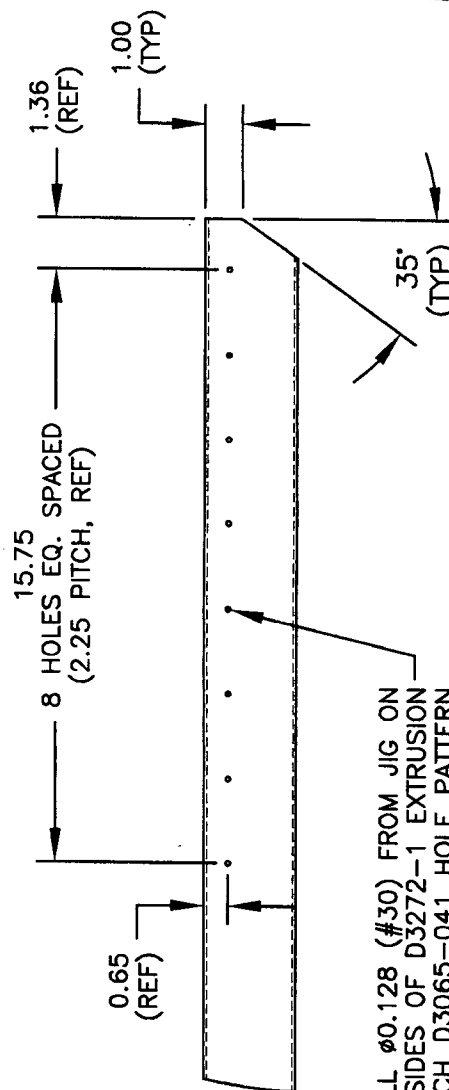
RELEASED

07.06.04



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.